



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 195702



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 In Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		7/5/19	0.00	0.65	Skidtubes - Bend		M66
120	Skidtubes - 2 - B4B	1 pcs		7/5/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		M66
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1		7/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		



Dart Aerospace Ltd.
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www.dartaerospace.com

Container No: S189209



Part: D205-634-041

Job No: 195702

Serial No/Batch: S189209

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3 FAA STC SR00563NY 08/08/11, EASA S

5189209x1

Plex 5/30/19 8:56 AM Dart.Guerin.Kimberley

150 QC 10

1
pcs

7/5/19

0.00 0.00

Skidtubes - 3 - B4B

Skidtubes - 4 - B4B

Skidtubes - 5 - B4B

Skidtubes - 6 - B4B

Skidtubes - 7 - B4B

QC 10 - 10

QC 10 - 18

QC 10 - 24

QC 10 - 43

QC 10 - 50

QC 10 - 58

QC 10 - 9

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

Handfinish - 1 - 1 - B4B

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 -
B4BHandfinish - 1 - 11 -
B4BHandfinish - 1 - 12 -
B4BHandfinish - 1 - 13 -
B4BHandfinish - 1 - 14 -
B4BHandfinish - 1 - 15 -
B4BHandfinish - 1 - 16 -
B4BHandfinish - 1 - 17 -
B4BHandfinish - 1 - 18 -
B4BHandfinish - 1 - 19 -
B4BHandfinish - 1 - 20 -
B4B

Handfinish - 1 - 21 -

JUN 19 2019

JUN 19 2019

JUN 20 2019

				B4B		
				Handfinish - 1 - 22 - B4B		
180 Powdercoat - 1 White GI(A)-B4B	1 pcs	7/5/19	0.00 0.34	Powdercoat - 1 - B4B		BE819-06-24
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
190 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10		M 19-6-21
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
200 Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 1.31	Handfinish - 4 - 1 - B4B		BE819-06-25
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
210 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10		DAS DAS 81 68 9-89 9-89 JUN 26 2019
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		

Plex 5/30/19 8:56 AM Dart.Guerin.Kimberley

DAS
15
9-89

220 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	JUL 30 2019
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	DAS
				Packaging 3 - 11 - B4B	75
				Packaging 3 - 12 - B4B	9-89
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
225 DC - 1 - B4B	1 pcs	7/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	JUL 30 2019
230 QC 21 - FG	1 pcs	7/5/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - FG - 53	DAS 21 JUL 30 2019

Part Op 110 - Skid tubes - 1-Bend as per program D2580.C on CNC Bender and Follo 16 2-Cut tubes as per Dwg. D2580 3- scribe
 Descriptions: batch# in aft end of tube

120 - Skid tubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skid tubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr *AKR ML39011*

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss (Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: *1:55*

OVEN TEMPERATURE: *320°*

FINISH TIME: 2:25 5175459.

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install Inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 5163437 Sikaflex expire date: 19/09 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 5163437 Sikaflex expire date: 19/09 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5185147

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	<u>5186624</u>
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	<u>5177025</u>
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	<u>5154382</u>
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5159769.</u>
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5149158-1</u>
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5180214.</u>
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5189025</u>
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5173297.</u>
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5066018</u>
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5185053</u>
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5182449</u>
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5185270</u>
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5186896.</u>
NAS1149C0332R	Washer	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5158078.</u>
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5178378</u>
				<u>M.U. 010572</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	4	0
140-Skidtubes - 3 - B4B	D2576-3	1	47	0
	D4202-1	20	857	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,014	0
	AN3-5A	2	194	0
	AN3C4A	50	1,176	0
	D2594-1	16	106	0
	D2594-3	16	411	0
	D2855	1	52	0
	D3564-11	1	6	0
	D3564-13	1	14	0
	D3564-5	1	1	0
	D3564-9	1	3	0
	NAS1149C0332R	50	3,404	0
	NAS1149D0332J	2	3,596	0

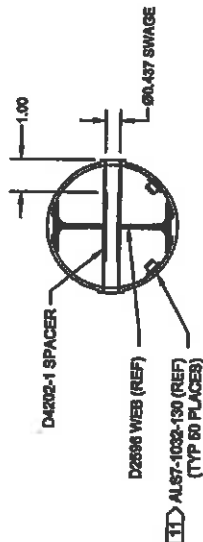
Part Specifications

Specifications could not be found.

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SECTION B-B
SCALE 5X

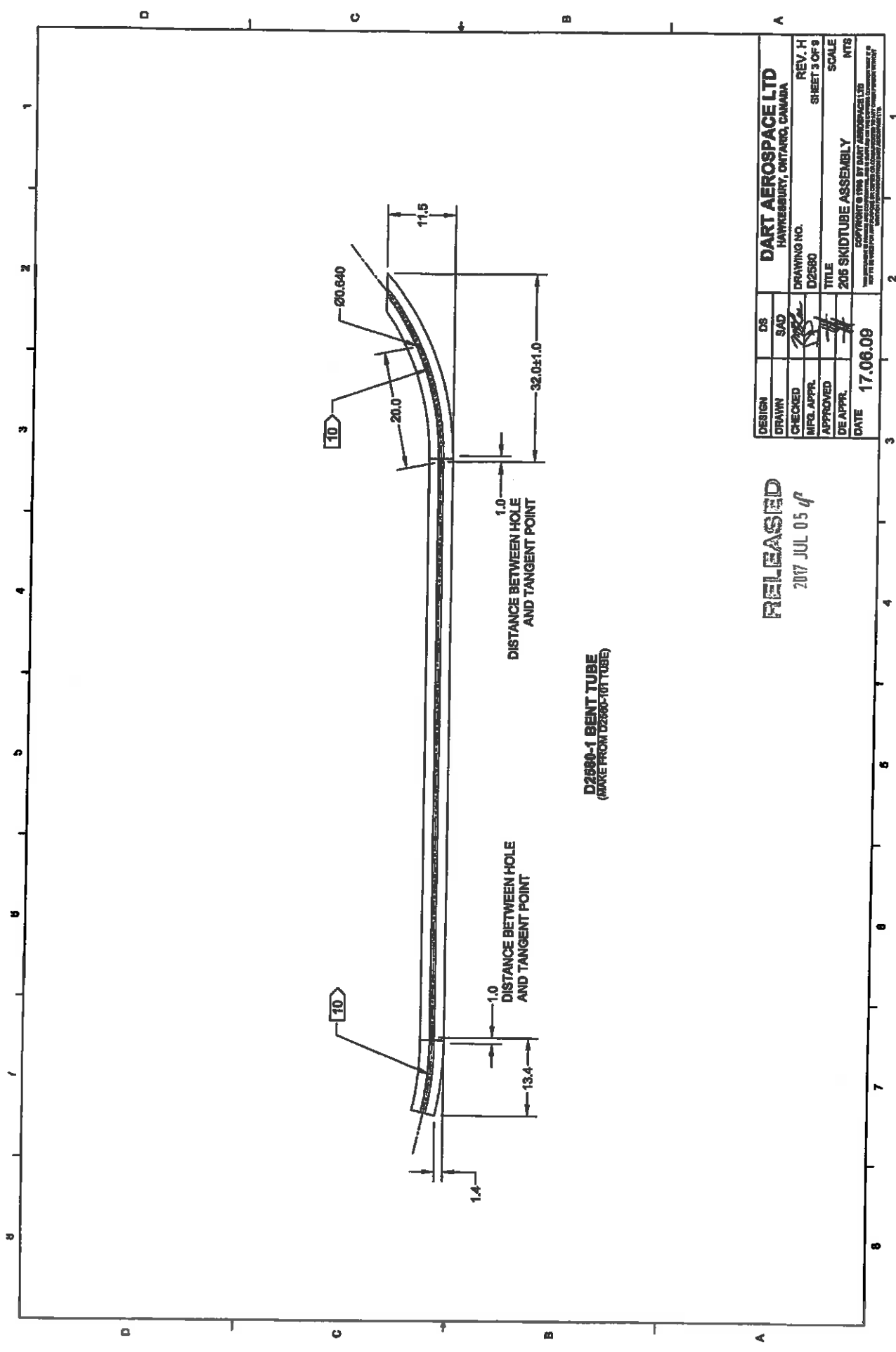


**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. INSERT D42X2-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER CSI 002
3. TRIM / GRIND FLUSH PER CSI 002

Diagram of a grinding wheel cross-section. The wheel is oval-shaped with a central hole. Labels include: "GRIND FLUSH 4 PL" pointing to the outer rim, "GRIND FLUSH" pointing to the inner rim, "D2576-3 STEP" pointing to the central hole, "LOCATION RIDGE ON UNDERSIDE OF D2576-3" pointing to a ridge on the bottom surface, and "V4" pointing to a small notch on the outer rim.

2017 JUL 05



D2580-1 BENT TUBE
(MAKE FROM D2580-10 TUBE)

DESIGN	D2	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
INFL. APPR.	<i>[Signature]</i>	D2580
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTS

RELEASED
2017 JUL 05 4P

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**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. CHAMFER HOLE 0.080 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE



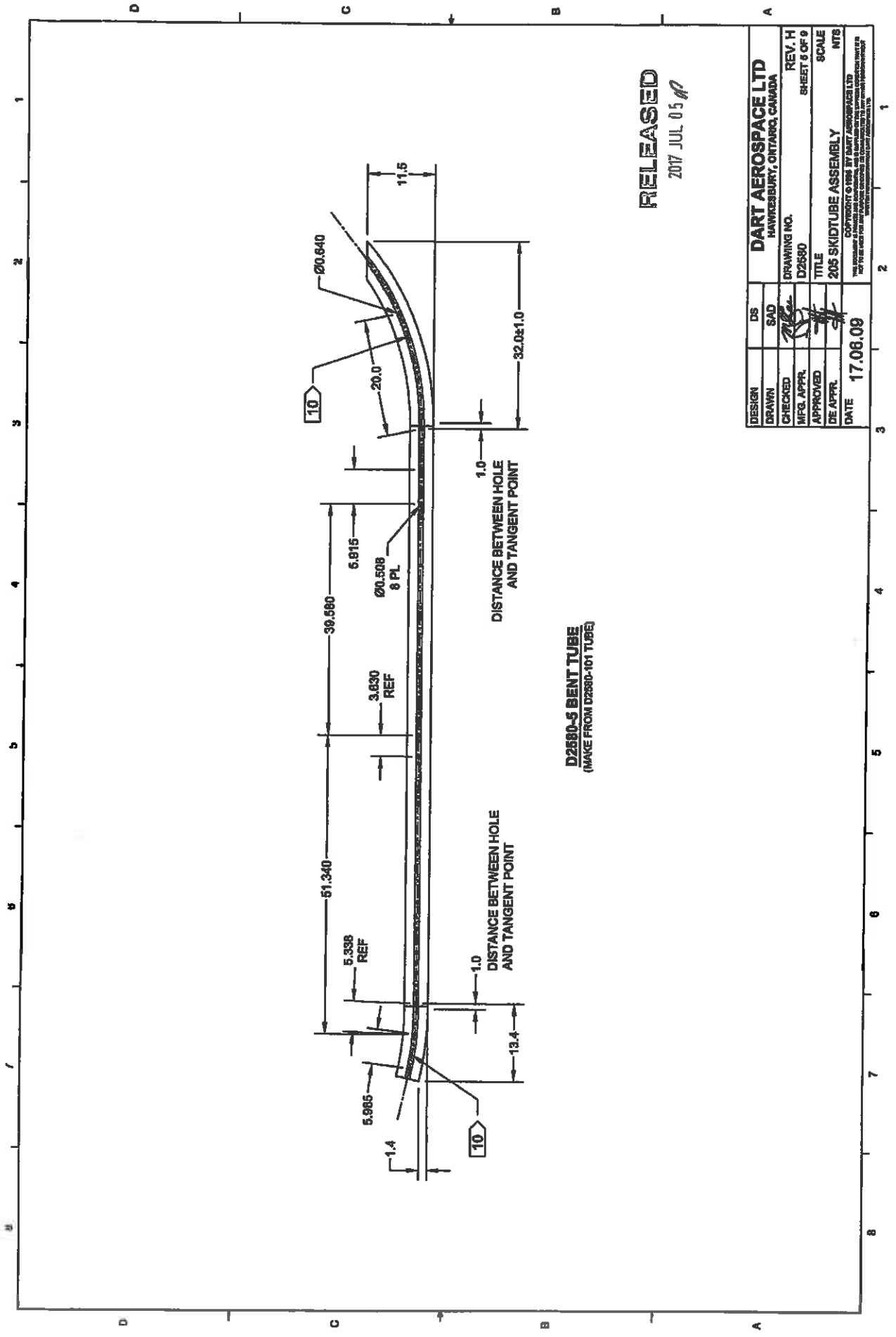
**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 4 OF 9	
DRAWN	SAD		
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MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DATE	17.06.09	TITLE 205 SKIDTUBE ASSEMBLY SCALE NTR	CONFIRMED BY DART AEROSPACE LTD WORK HEREON IS UNCLASSIFIED AND IS AVAILABLE FOR REPRODUCTION WITHOUT FEE WORK HEREON IS UNCLASSIFIED AND IS AVAILABLE FOR REPRODUCTION WITHOUT FEE

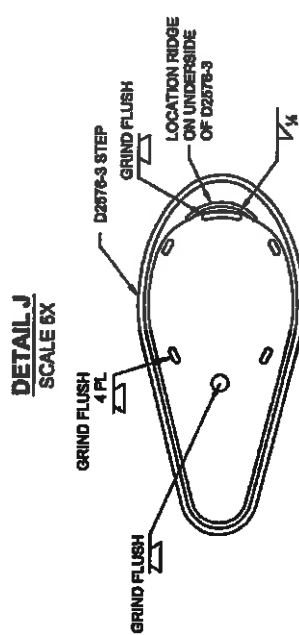
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D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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DE APPR.	<i>[Signature]</i>	SCALE			NTS
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DETAIL H
SCALE 5X

SECTION HI
SCALE 5X

DETAIL J
SCALE 6X

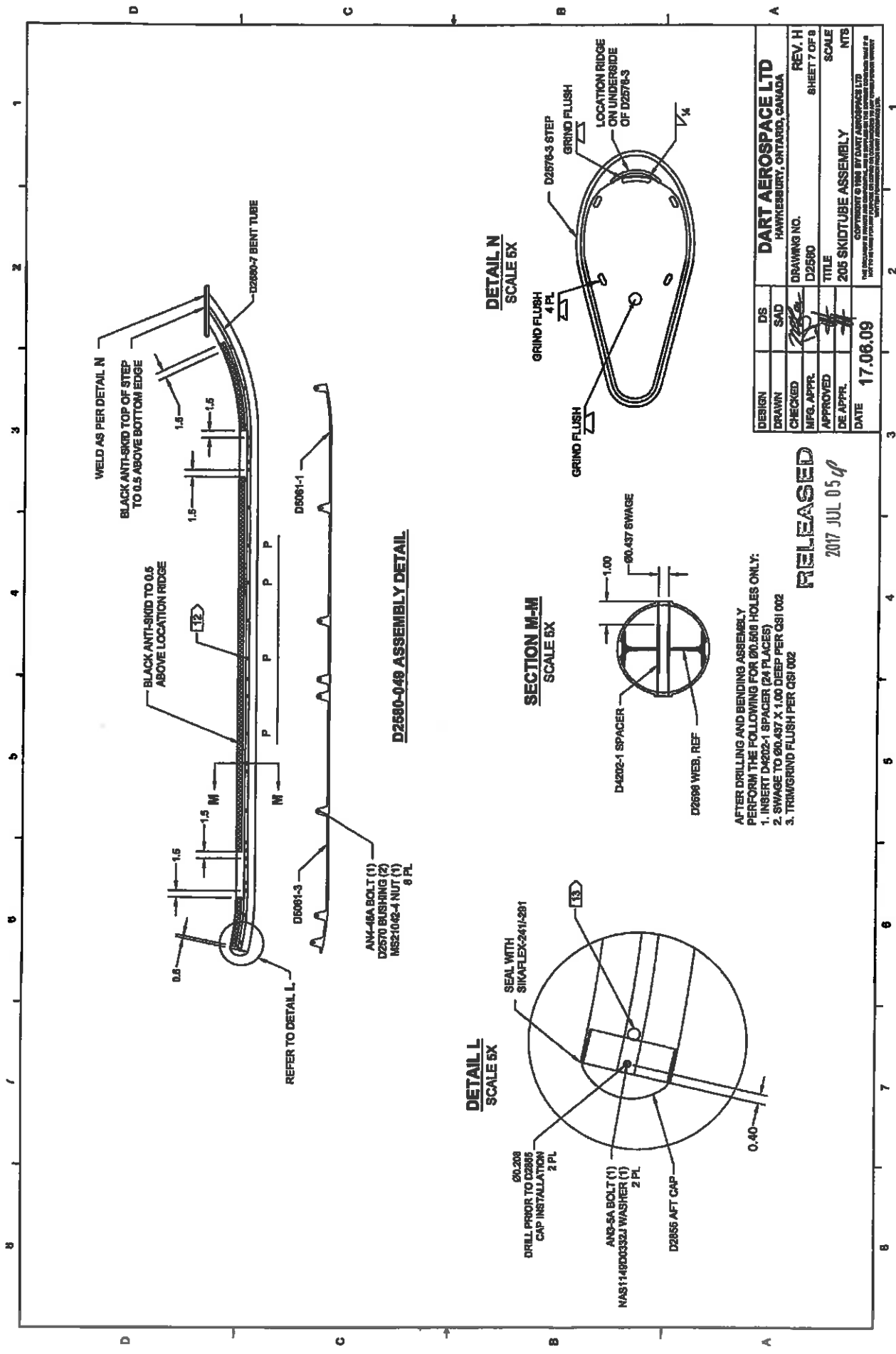
**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

100
 100
 100
 100
 100
 100

2017 JUL 05 4P

DESIGN	DS	DART AEROSPACE LTD HAWESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 1 OF 9 SCALE NTS TITLE 20 SKIDTUBE ASSEMBLY COPYRIGHT © 1984 BY DART AEROSPACE LTD This document is the property of Dart Aerospace Ltd. It is to be used for the project and quantity specified. It is not to be reproduced or transmitted in any form or by any means, electronic or mechanical, including photocopying, recording, or by any information storage and retrieval system, without the written permission of Dart Aerospace Ltd.	
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MFGR. APRR.	<i>BS</i>		
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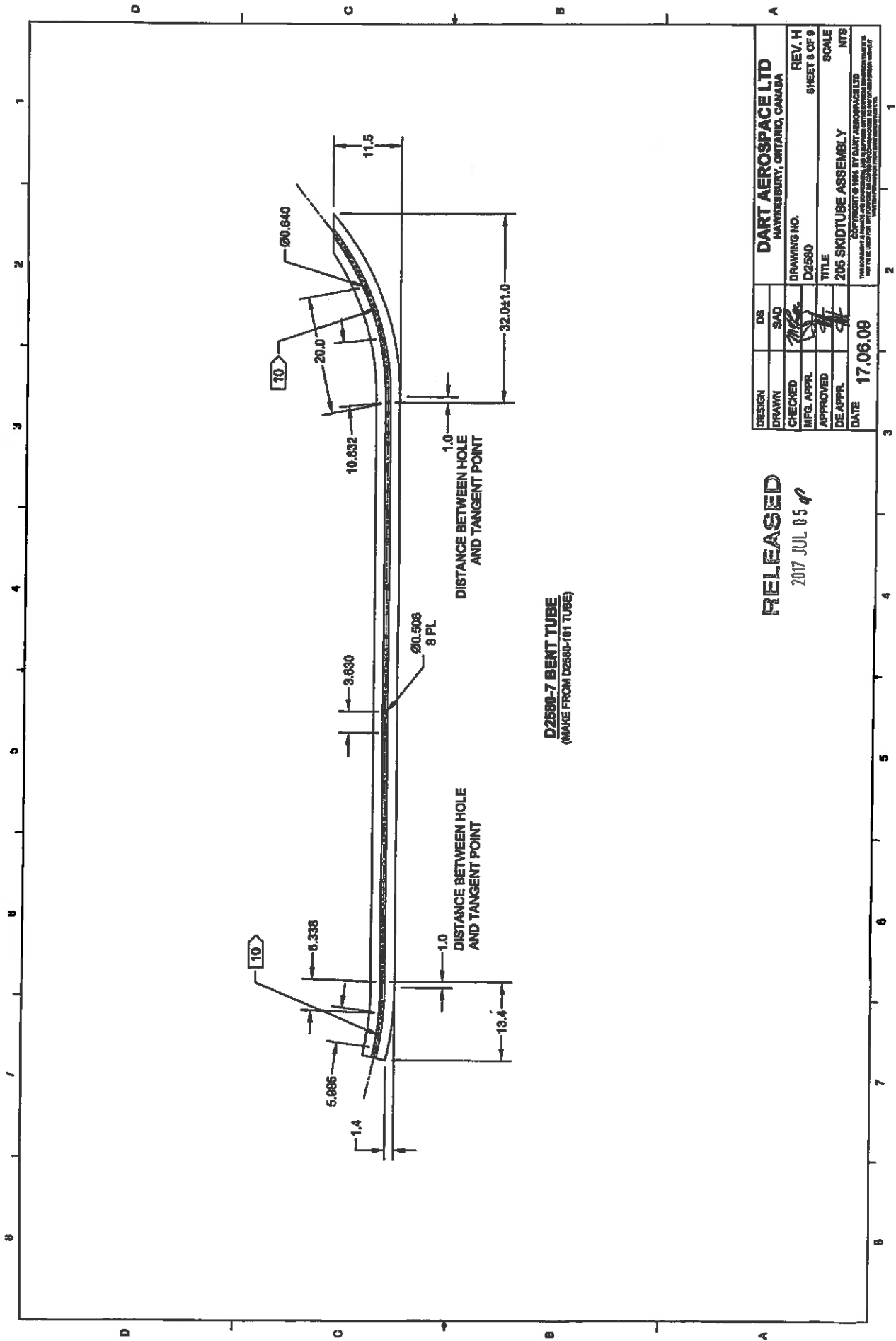


AFTER DRILLING AND BENDING ASSEMBLY
 PERFORM THE FOLLOWING FOR Ø0.5M HOLES ONLY:
 1. INSERT D4202-1 SPACER (24 PLACES)
 2. SWAGE TO Ø0.437 X 1.00 DEEP PER CSI 002
 3. TRIM/GRIND FLUSH PER CSI 002

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APPROVED			SHEET 7 OF 8
DE APPR.			SCALE
DATE	17.06.09		TITLE
			205 SKIDTUBE ASSEMBLY
			NTS

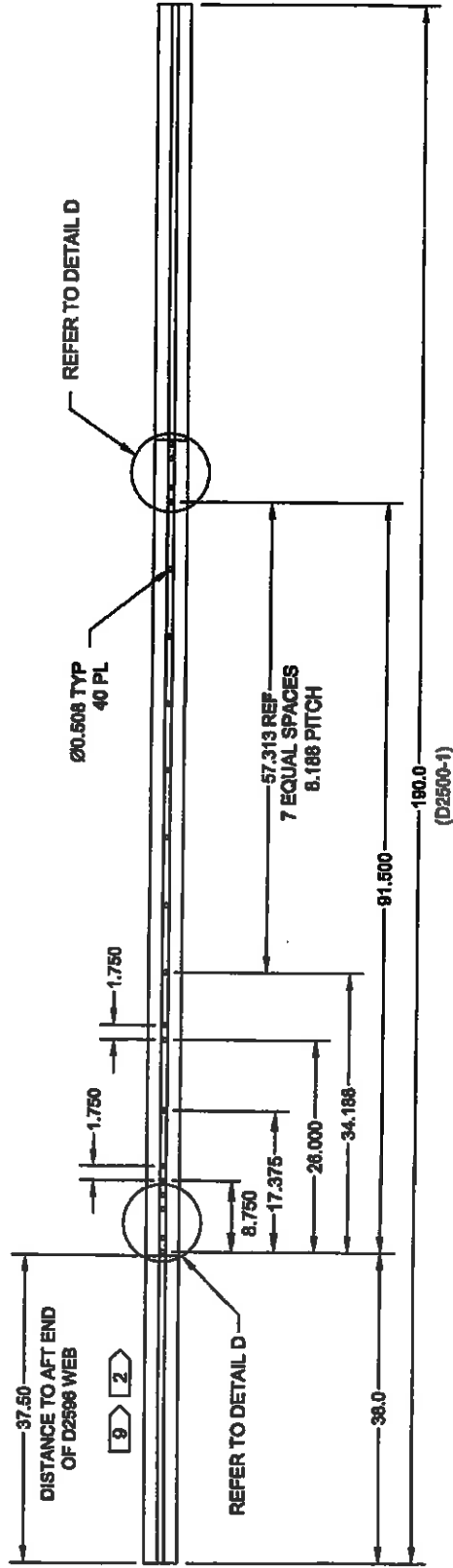
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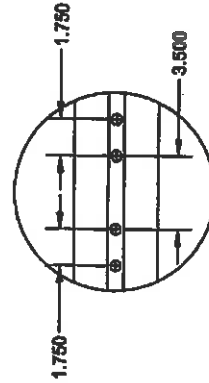
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CHECKED	MPG	DRAWING NO. D2580
MPG APPR	MPG	REV. H SHEET 8 OF 9
APPROVED	MPG	TITLE 206 SKIDTUBE ASSEMBLY
DE APPR	MPG	SCALE NTS
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D2590-101 TUBE



DETAIL D
SCALE 5X

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CHECKED	REV. H	DRAWING NO.
MFG. APPR.	D2590	SHEET 9 OF 9
APPROVED	TITLE	SCALE
DE APPR.	205 SKIDTUBE ASSEMBLY	NTS
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